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D2512
Job Sheet 192454



Part No: D2512

Job Qty: 1 pcs

Part Name: Basket Lid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: Stock

Description: *Stop*

Note: DWG REV H Rev IPP:M03.01.31 AddedD2012-117forD130-701-041 KJ/RF IPP Rev:N 06.04.05 Added level21 EC IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified by:EC IPP Rev:R 10.06.29 added pressure wash DD ver:EC IPP REV:S 12.07.27 AS PER DWG REV.F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG REV.G DD VERF:EC IPP REV:U 16.11.03 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	5/10/19		0.00	15.13	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		CC
							Large Fab - 8		
110	QC 9	1 pcs	5/10/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS 43 9-89
							QC 9 - 50		
120	QC 5	1 pcs	5/10/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS 43 9-89
							QC 5 - 49		
							QC 5 - 51		

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
125 Handfinish - 2-1 Pressure- B4B	1 pcs	5/10/19	0.00	1.35		Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	D.R 19/04/17
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130 Powdercoat - 1 White Gl(A)- B4B	1 pcs	5/10/19	0.00	0.77		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BE 19-4-17.
						Powdercoat - 4 - B4B	
START: 12:15 O.V.T: 375° FINISH: 12:30							
140 Handfinish - 3-1- WingWalk- B4B	1 pcs	5/10/19	0.00	1.35		Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	BEB 19-04-26
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	5/10/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	ML 19-4-26
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
160 Packaging 3-1 - Stock - B4B	1 pcs	5/10/19	0.00	0.00		Packaging 3 - 1 - B4B	ML 19-4-26
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 -	
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						B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
						170 QC 21 - SA	
						1	
						pcs	
						5/10/19	
						0.00	
						0.00	
						QC 21 - SA - 21	DAS
						QC 21 - SA - 70	21
						QC 21 - SA - 53	9-39

APR 29 2019

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____ 1- Weld ribs as per Dwg D2512 using Welding Jig DT 9436 2- WELD
 Descriptions: MESH AND REMOVE SECTIONS OF MESH WHERE INDICATED AS PER DWG

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

125 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

130 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)1- Plug all holes prior to Powdercoat START TIME: _____

FINISH TIME: _____ START TIME: _____

140 - (Wing Walk as per dwg QSI005 4.4 Batch: 5149 584) Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: 5149 584

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2232-1 ✓	Basket Hinge	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5097498
D2236	Lid Rib	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	5167423
D2506 ✓	Label Plate	1 pcs (1 ea) ✓	100-Large Fab - Welded Assy-1	5072537
D2512-3 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5150964
D2512-5 ✓	Rib	6 pcs (6 ea) ✓	100-Large Fab - Welded Assy-1	5166279
D2512-7 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Welded Assy-1	5155739
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5155219
D3825-043 ✓	Rib Assembly (Basket End, Lid)	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5166726
M304EX0.75-16F ✓	Expanded Metal Flat SS	32 sf (32 ea) ✓	100-Large Fab - Welded Assy-1	5147379

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2232-1	2	5	0
	D2236	4	4	0
	D2506	1	14	0
	D2512-3	2	6	0
	D2512-5	6	7	0
	D2512-7	3	1	0
	D2581	2	79	0
	D3825-043	2	0	0
	M304EX0.75-16F	32	1,177	0

Part Specifications

Specifications could not be found.

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CANADA
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Container No: S169279



Part: D2512

Job No: 192454

Serial No/Batch: S169279

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/03/19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								